



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
  
Tel (613) 632-5200  
Fax 613 632-5246

D205-634-141  
Job Sheet 203969



Part No: D205-634-141      Job Qty: 1 pcs  
Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH  
  
Part Weight: 0 lbs      Status: New      Priority: Medium  
Job Created: 11/29/19      Job Tracking No:  
Due Date: 12/24/19      Created By: Marie Lajeunesse  
Type: Stock      Description:  
Note: D205-634 REV.I/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM  
Ship Via:

Bill of Materials

Job Routing

| Op No | Operation                  | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier    |           | Sign-off |
|-------|----------------------------|-------|------------|----------|-----------|---------|------------------------|-----------|----------|
|       |                            |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier  | Lead Time |          |
| 110   | Skidtubes - 1              | 1 pcs | 12/24/19   |          | 0.00      | 2.00    | Skidtubes - 1          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 2          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 3          |           | MLA      |
|       |                            |       |            |          |           |         | Skidtubes - 4          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 5          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 6          |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 7          |           |          |
| 120   | Skidtubes - Bend - 2 - B4B | 1 pcs | 12/24/19   |          | 0.50      | 1.00    | Skidtubes - Bend - B4B |           | MLA      |
| 130   | Skidtubes - 2 - B4B        | 1 pcs | 12/24/19   |          | 0.00      | 2.00    | Skidtubes - 1 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 2 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 3 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 4 - B4B    |           | TF       |
|       |                            |       |            |          |           |         | Skidtubes - 5 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 6 - B4B    |           |          |
|       |                            |       |            |          |           |         | Skidtubes - 7 - B4B    |           |          |
| 140   | QC 5                       | 1 pcs | 12/24/19   |          | 0.00      | 0.00    | QC 5 - 10              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 12              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 17              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 18              |           | BC       |
|       |                            |       |            |          |           |         | QC 5 - 19              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 22              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 24              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 3               |           |          |
|       |                            |       |            |          |           |         | QC 5 - 43              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 49              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 51              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 58              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 68              |           |          |
|       |                            |       |            |          |           |         | QC 5 - 9               |           |          |
|       |                            |       |            |          |           |         | QC 5 - 50              |           |          |



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CANADA  
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Email: sales@dartaero.com  
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Container No: S236974



Part: D205-634-141

Job No: 203969

Serial No/Batch: S236974

Revision: H/I

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 2, FAA STC SRD0563!

|                                     |          |          |           |                          |                       |
|-------------------------------------|----------|----------|-----------|--------------------------|-----------------------|
|                                     |          |          |           | QC 5 - 30                |                       |
|                                     |          |          |           | QC 5 - 40                |                       |
|                                     |          |          |           | QC 5 - 61                |                       |
|                                     |          |          |           | QC 5 - 81                |                       |
|                                     |          |          |           |                          |                       |
| 150 Skidtubes - 3 - B4B             | 1<br>pcs | 12/24/19 | 0.00 2.00 | Skidtubes - 1 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 2 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 3 - B4B      | MLG                   |
|                                     |          |          |           | Skidtubes - 4 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 5 - B4B      | BE                    |
|                                     |          |          |           | Skidtubes - 6 - B4B      |                       |
|                                     |          |          |           | Skidtubes - 7 - B4B      |                       |
| 160 QC 10                           | 1<br>pcs | 12/24/19 | 0.00 0.00 | QC 10 - 10               |                       |
|                                     |          |          |           | QC 10 - 18               |                       |
|                                     |          |          |           | QC 10 - 24               |                       |
|                                     |          |          |           | QC 10 - 43               |                       |
|                                     |          |          |           | QC 10 - 50               |                       |
|                                     |          |          |           | QC 10 - 58               |                       |
|                                     |          |          |           | QC 10 - 9                |                       |
|                                     |          |          |           | QC 10 - 68               | DAS<br>DEC 10 2019 68 |
|                                     |          |          |           |                          | 9-89                  |
| 170 QC 5                            | 1<br>pcs | 12/24/19 | 0.00 0.00 | QC 5 - 10                |                       |
|                                     |          |          |           | QC 5 - 12                |                       |
|                                     |          |          |           | QC 5 - 17                |                       |
|                                     |          |          |           | QC 5 - 18                |                       |
|                                     |          |          |           | QC 5 - 19                |                       |
|                                     |          |          |           | QC 5 - 22                |                       |
|                                     |          |          |           | QC 5 - 24                |                       |
|                                     |          |          |           | QC 5 - 3                 |                       |
|                                     |          |          |           | QC 5 - 43                |                       |
|                                     |          |          |           | QC 5 - 49                |                       |
|                                     |          |          |           | QC 5 - 51                |                       |
|                                     |          |          |           | QC 5 - 58                |                       |
|                                     |          |          |           | QC 5 - 68                | DAS<br>DEC 10 2019 68 |
|                                     |          |          |           | QC 5 - 9                 | 9-89                  |
|                                     |          |          |           | QC 5 - 50                |                       |
|                                     |          |          |           | QC 5 - 30                |                       |
|                                     |          |          |           | QC 5 - 40                |                       |
|                                     |          |          |           | QC 5 - 61                |                       |
|                                     |          |          |           | QC 5 - 81                |                       |
| 180 Handfinish - 2-1 Pressure- B4B  | 1<br>pcs | 12/24/19 | 0.00 0.50 | Handfinish - 2 - 1 - B4B |                       |
|                                     |          |          |           | Handfinish - 2 - 2 - B4B | DEC 11 2019           |
|                                     |          |          |           | Handfinish - 2 - 3 - B4B |                       |
|                                     |          |          |           | Handfinish - 2 - 4 - B4B |                       |
| 190 Powdercoat - 1 White Gl(A)- B4B | 1<br>pcs | 12/24/19 | 0.00 0.80 | Powdercoat - 1 - B4B     |                       |
|                                     |          |          |           | Powdercoat - 2 - B4B     |                       |
|                                     |          |          |           | Powdercoat - 3 - B4B     | BE 10-10-11           |
|                                     |          |          |           | Powdercoat - 4 - B4B     |                       |
| 200 QC 3                            | 1<br>pcs | 12/24/19 | 0.00 0.00 | QC 3 - 10                |                       |
|                                     |          |          |           | QC 3 - 13                |                       |
|                                     |          |          |           | QC 3 - 15                |                       |
|                                     |          |          |           | QC 3 - 17                |                       |
|                                     |          |          |           | QC 3 - 18                |                       |
|                                     |          |          |           | QC 3 - 2                 |                       |
|                                     |          |          |           | QC 3 - 28                |                       |
|                                     |          |          |           | QC 3 - 3                 |                       |
|                                     |          |          |           | QC 3 - 30                |                       |
|                                     |          |          |           | QC 3 - 34                |                       |

|                                             |          |          |      |      |                             |                              |
|---------------------------------------------|----------|----------|------|------|-----------------------------|------------------------------|
|                                             |          |          |      |      | QC 3 - 36                   |                              |
|                                             |          |          |      |      | QC 3 - 41                   |                              |
|                                             |          |          |      |      | QC 3 - 51                   |                              |
|                                             |          |          |      |      | QC 3 - 58                   |                              |
|                                             |          |          |      |      | QC 3 - 59                   | BE819-12-11                  |
|                                             |          |          |      |      | QC 3 - 68                   |                              |
|                                             |          |          |      |      | QC 3 - 9                    |                              |
|                                             |          |          |      |      | QC 3 - 40                   |                              |
|                                             |          |          |      |      | QC 3 - 19                   |                              |
|                                             |          |          |      |      | QC 3 - 43                   |                              |
|                                             |          |          |      |      | QC 3 - 24                   |                              |
|                                             |          |          |      |      | QC 3 - 61                   |                              |
|                                             |          |          |      |      | QC 3 - 81                   |                              |
|                                             |          |          |      |      |                             |                              |
| 210 Handfinish - 3-1- WingWalk-<br>B4B      | 1<br>pcs | 12/24/19 | 0.00 | 1.33 | Handfinish - 3 - 1 -<br>B4B |                              |
|                                             |          |          |      |      | Handfinish - 3 - 2 -<br>B4B | BE819-12.                    |
|                                             |          |          |      |      | Handfinish - 3 - 3 -<br>B4B |                              |
|                                             |          |          |      |      | Handfinish - 3 - 4 -<br>B4B |                              |
|                                             |          |          |      |      | Handfinish - 3 - 5 -<br>B4B |                              |
| 220 QC 5                                    | 1<br>pcs | 12/24/19 | 0.00 | 0.00 | QC 5 - 10                   |                              |
|                                             |          |          |      |      | QC 5 - 12                   |                              |
|                                             |          |          |      |      | QC 5 - 17                   |                              |
|                                             |          |          |      |      | QC 5 - 18                   |                              |
|                                             |          |          |      |      | QC 5 - 19                   |                              |
|                                             |          |          |      |      | QC 5 - 22                   |                              |
|                                             |          |          |      |      | QC 5 - 24                   |                              |
|                                             |          |          |      |      | QC 5 - 3                    |                              |
|                                             |          |          |      |      | QC 5 - 43                   |                              |
|                                             |          |          |      |      | QC 5 - 49                   |                              |
|                                             |          |          |      |      | QC 5 - 51                   |                              |
|                                             |          |          |      |      | QC 5 - 58                   |                              |
|                                             |          |          |      |      | QC 5 - 68                   | DAS<br>DEC 16 201968<br>9-89 |
|                                             |          |          |      |      | QC 5 - 9                    |                              |
|                                             |          |          |      |      | QC 5 - 50                   |                              |
|                                             |          |          |      |      | QC 5 - 30                   |                              |
|                                             |          |          |      |      | QC 5 - 40                   |                              |
|                                             |          |          |      |      | QC 5 - 61                   |                              |
|                                             |          |          |      |      | QC 5 - 81                   |                              |
| 230 Packaging 3-1 - Stock - B4B             | 1<br>pcs | 12/24/19 | 0.00 | 0.00 | Packaging 3 - 1 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 2 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 3 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 4 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 5 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 6 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 7 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 8 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 9 - B4B       |                              |
|                                             |          |          |      |      | Packaging 3 - 10 -<br>B4B   |                              |
|                                             |          |          |      |      | Packaging 3 - 11 -<br>B4B   |                              |
|                                             |          |          |      |      | Packaging 3 - 12 -<br>B4B   |                              |
|                                             |          |          |      |      | Packaging 3 - 13 -<br>B4B   |                              |
|                                             |          |          |      |      | Packaging 3 - 14 -<br>B4B   |                              |
| Plex 11/29/19 1:27 PM Dart.lajeunesse.marie |          |          |      |      |                             |                              |

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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 16 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 17 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 18 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 19 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 20 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 21 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 22 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 23 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 24 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 25 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 26 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 27 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 28 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 29 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 30 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 31 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 32 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 33 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          | Packaging 3 - 34 - B4B |                 |
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| 235                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | DC - 1 - B4B | 1   | 12/24/19 | 0.00 0.00              | DC - 1 - B4B    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              | pcs |          |                        | DC - 2 - B4B    |
| 240                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | QC 21 - FG   | 1   | 12/24/19 | 0.00 0.00              | QC 21 - FG - 21 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              | pcs |          |                        | QC 21 - FG - 70 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |     |          |                        | QC 21 - SA - 53 |
| <div>Part Op 110 - (Skidtubes)1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL Descriptions: 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)<br/>120 - (CNC Delta 100 Bender)1-Bend as per program D2580.C on CNC Bender and Folio FT 16<br/>130 - (Skidtubes)1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.<br/>140 - (QC5- Inspect part completeness to step on W/O)<br/>150 - (Skidtubes)1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR<br/>160 - QC10- Inspect visual per QSI004- ground welds)<br/>170 - QC5- Inspect part completeness to step on W/O) Production .0000 * Attachments 180 HandFinish And realodine tube as per QSI 005 HandFinish2 (Pressure Wash p<br/>180 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)And realodine tube as per QSI 005<br/>190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME:<br/>200 - (QC3- Inspect Part Finish)</div> |              |     |          |                        |                 |

20/03

210 - (Assemble as per dwg)1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 5231095 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# 5229693.  
220 - (QC5- Inspect part completeness to step on W/O)Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024  
230 - 1 (Identify as per dwg & Stock Location: \_\_\_\_\_)Identify and pack for shipping as per PPPD205-634-141 Location : FG084  
235 - (Document Control)Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004  
240 - (QC21- Final Inspection - Work Order Release)

Job BOM

| Part / Item   | Component Name          | Quantity       | Operation                          | Container |
|---------------|-------------------------|----------------|------------------------------------|-----------|
| D2580-1       | 205 Bent Tube           | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | 5224585   |
| D2576-3       | Step (Machining Detail) | 1 pcs (1 ea)   | 150-Skidtubes - 3 - B4B            | 5177095   |
| D4202-1       | Spacer                  | 24 pcs (24 ea) | 150-Skidtubes - 3 - B4B            | 5184048   |
| AN3-5A        | Bolt                    | 2 Ea (2 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 5216385   |
| AN4-45A       | Bolt                    | 8 Ea (8 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 5228006   |
| D2570         | Bushing                 | 16 pcs (16 ea) | 210-Handfinish - 3-1- WingWalk-B4B | 5221878   |
| D2594-1       | Plug                    | 8 pcs (8 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5229062   |
| D2594-3       | O-Ring                  | 8 pcs (8 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5045932   |
| D2855         | Cap                     | 1 pcs (1 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5126188   |
| D4406-041     | Fwd Wearplate Assembly  | 1 pcs (1 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5190047   |
| D4406-043     | Aft Wearplate Assembly  | 1 pcs (1 ea)   | 210-Handfinish - 3-1- WingWalk-B4B | 5198237   |
| MS21042-4     | Nut                     | 8 Ea (8 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 5158589   |
| NAS1149D0332J | Washer                  | 2 Ea (2 ea)    | 210-Handfinish - 3-1- WingWalk-B4B | 5178328   |

M U 013417

Job Allocations

| Operation                          | Component Part | Required | Inventory | Allocated |
|------------------------------------|----------------|----------|-----------|-----------|
| 110-Skidtubes - 1                  | D2580-1        | 1        | 10        | 0         |
| 150-Skidtubes - 3 - B4B            | D2576-3        | 1        | 59        | 0         |
|                                    | D4202-1        | 24       | 1,222     | 0         |
| 210-Handfinish - 3-1- WingWalk-B4B | AN3-5A         | 2        | 199       | 0         |
|                                    | AN4-45A        | 8        | 29        | 0         |
|                                    | D2570          | 16       | 512       | 0         |
|                                    | D2594-1        | 8        | 188       | 0         |
|                                    | D2594-3        | 8        | 277       | 0         |
|                                    | D2855          | 1        | 67        | 0         |
|                                    | D4406-041      | 1        | 2         | 0         |
|                                    | D4406-043      | 1        | 2         | 0         |
|                                    | MS21042-4      | 8        | 68        | 0         |
|                                    | NAS1149D0332J  | 2        | 2,879     | 0         |

Part Specifications

Specifications could not be found.

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| ITEM | QTY<br>-041 | QTY<br>-046 | QTY<br>-047 | QTY<br>-048 | PART NUMBER                                                               | DESCRIPTION        |
|------|-------------|-------------|-------------|-------------|---------------------------------------------------------------------------|--------------------|
| 1    | X           |             |             |             | D2680-041                                                                 | SKIDTUBE ASSEMBLY  |
| 2    |             | X           |             |             | D2680-046                                                                 | SKIDTUBE ASSEMBLY  |
| 3    |             |             | X           |             | D2680-047                                                                 | SKIDTUBE ASSEMBLY  |
| 4    |             |             |             | X           | D2680-048                                                                 | SKIDTUBE ASSEMBLY  |
| 20   | 1           | 1           | 1           | 1           | D2680-1-100                                                               | EXTRUSION          |
| 21   |             |             | 18          | 18          | D2670                                                                     | BUSHING            |
| 22   | 1           | 1           | 1           | 1           | D2676-3                                                                   | STEP               |
| 23   |             | 4           |             |             | D2679                                                                     | SPACER             |
| 24   | 18          | 18          | 8           | 8           | D2684-1                                                                   | PLUG               |
| 25   | 18          | 18          | 8           | 8           | D2684-3                                                                   | O-RING             |
| 26   | 1           | 1           | 1           | 1           | D2686                                                                     | 205 WEB            |
| 27   | 1           | 1           | 1           | 1           | D2688                                                                     | AFT CAP            |
| 28   | 1           | 1           |             |             | D2684-5                                                                   | WEARSHOE           |
| 29   | 1           | 1           |             |             | D2684-9                                                                   | WEARSHOE           |
| 30   | 1           | 1           |             |             | D2684-11                                                                  | WEARSHOE           |
| 31   | 1           | 1           |             |             | D2684-13                                                                  | WEARSHOE           |
| 32   | 20          | 20          | 24          | 24          | D2682-1                                                                   | SPACER             |
| 33   |             |             | 1           |             | D4408-041                                                                 | WEARPLATE ASSEMBLY |
| 34   |             |             | 1           |             | D4408-043                                                                 | WEARPLATE ASSEMBLY |
| 35   |             |             |             | 1           | D2681-1                                                                   | FRND WEARPLATE     |
| 36   |             |             |             | 1           | D2681-5                                                                   | AFT WEARPLATE      |
| 50   | 80          | 80          |             |             | AL57-1032-130<br>or AK37-1032-130<br>or AK34-1032-130<br>or AEL5-1032-130 | INSERT             |
| 51   | 80          | 80          |             |             | AK34A                                                                     | BOLT               |
| 52   | 2           | 2           | 2           | 2           | AK34A                                                                     | BOLT               |
| 53   |             |             | 8           | 8           | AK4-4BA                                                                   | BOLT               |
| 54   | 80          | 80          |             |             | NAS114R2C32CR                                                             | WASHER (AN66NC10L) |
| 55   | 2           | 2           | 2           | 2           | NAS114R2C32L                                                              | WASHER (AN66NC10L) |
| 56   |             |             | 8           | 8           | MS21042-4                                                                 | NUT (OR MS21042L4) |

# GENERAL NOTES:

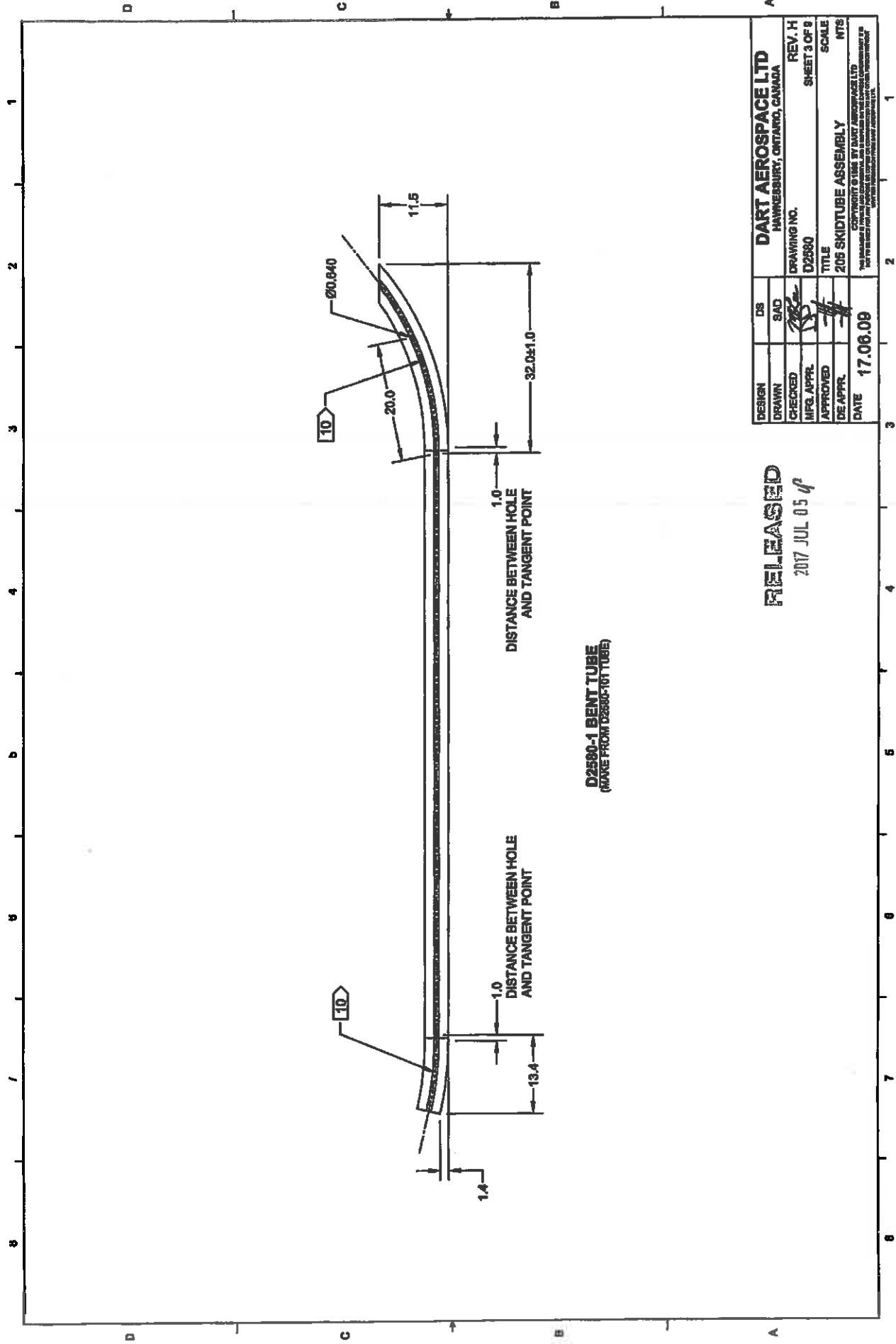
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART CSI 008.4.1 PRIOR TO INSERTING D2686 WEB. PWDYER COAT (-046) GREEN SANDTEX (REF 4.3.2.8) PER DART CSI 008.4.3. PWDYER COAT (-048) GREEN SANDTEX (REF 4.3.2.8) PER DART CSI 008.4.3. BLACK ANTI-SLID PAINT AS INDICATED PER DART CSI 008.4.4.
- 3) TOLERANCES ARE PER DART CSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SWAMP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2680-041 = 33.7 lbs  
D2680-046 = 46.1 lbs  
D2680-047 = 32.0 lbs  
D2680-048 = 32.0 lbs
- 8) WELDING PER DART CSI 004.
- 9) INSERT D2686 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIMPLEX-241 ADHESIVE PER DART CSI 018 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A MAXIMUM RADIUS OF 90. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWED IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTE217 & DTE217-01 ONLY FOR D2680-041/046 TO LOCATE AND DRILL 50.287 HOLES FOR WEARSHOE INSERTS. INSTALL ALL 50.287 HOLES PER SECTIONS B-5 AND F-6 (60 INCHES) AFTER FINISH. INSTALL AK34A BOLTS AND NAS114R2C32R WASHERS WITH SIMPLEX-241-541.
- 12) INSERT D2684-1 PLUG CW/D2684-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES FOR D2684-1/046 AND 18 PLACES FOR D2684-1/048).
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2686 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.

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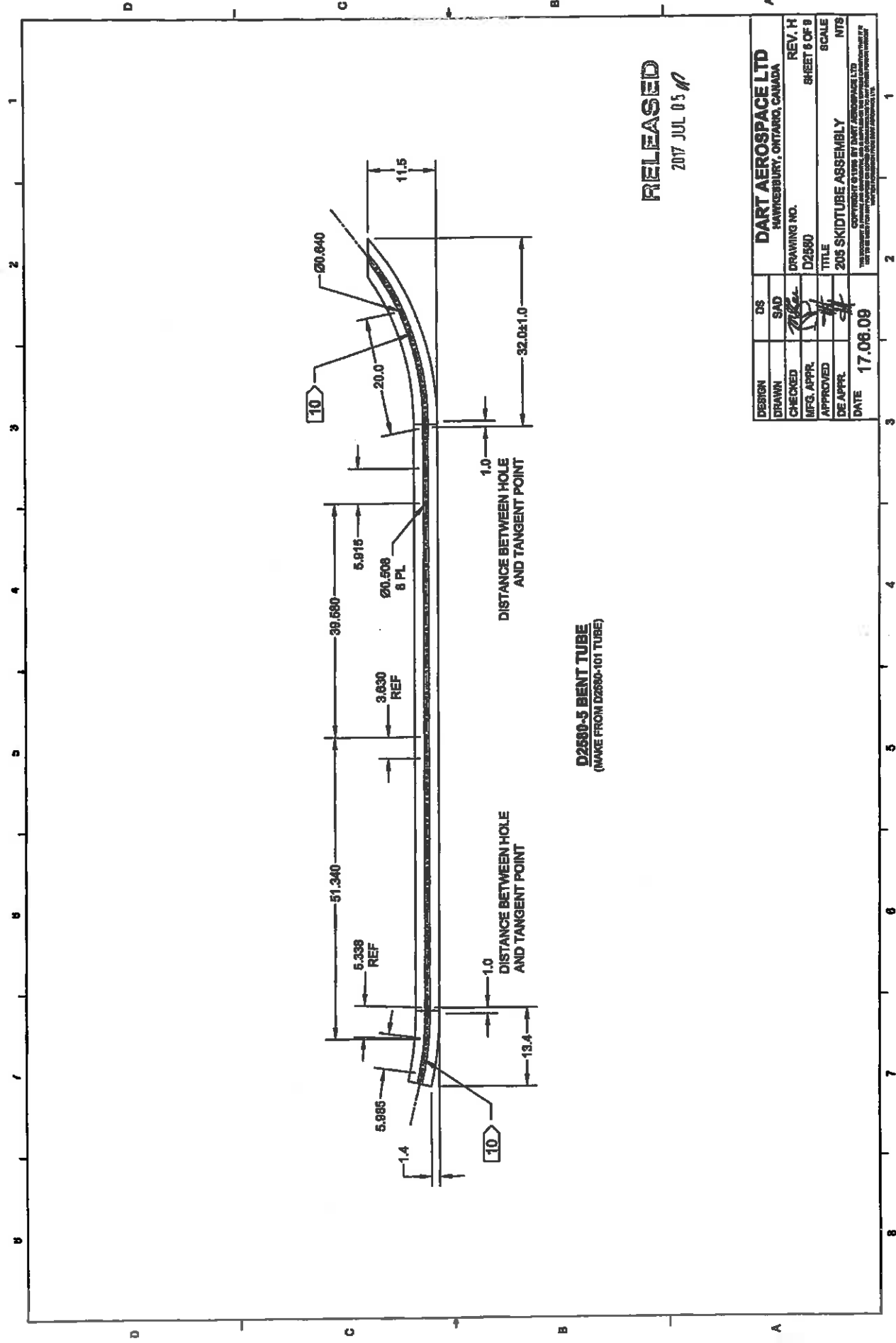
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|                                                   |                                                                                                                                                           |              |          |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|----------|
| H                                                 | SHEET: PL DELETE D2686-1A/1-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS                                 | SAD          | 17.06.09 |
| G                                                 | ADDED -048 -047 WEIGHT UPDATED PER D26 9688                                                                                                               | AS           | 14.04.09 |
| F                                                 | INCORPORATE DED D2680-E-1 PER PART 216                                                                                                                    | DC           | 13.06.09 |
| E                                                 | ADD D2680-047 (2N CA-7) AND D2686-7 (2N B3-4); INCLUDED DED D2680-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTE217 & DTE217 WAS DTE217-018 (2N CA-1) | RF           | 11.06.21 |
| D                                                 | CHANGE TO 83 WEARPLATES AND GASKETS, INCLUDE DED 91241 9183                                                                                               | PH           | 07.04.06 |
| C                                                 | REDRAWN, INCLUDED DED 9004/ 8027                                                                                                                          | CP           | 09.09.28 |
| B                                                 | AS MANUFACTURED                                                                                                                                           | DS           | 05.12.02 |
| A                                                 | NEW ISSUE                                                                                                                                                 | DS           | 05.02.16 |
| REV.                                              | DESCRIPTION                                                                                                                                               | BY           | DATE     |
| DESIGN                                            | DS                                                                                                                                                        |              |          |
| DRAWN                                             | SAD                                                                                                                                                       |              |          |
| CHECKED                                           | <i>[Signature]</i>                                                                                                                                        |              |          |
| INFS. APPR.                                       | D2680                                                                                                                                                     |              |          |
| APPROVED                                          | <i>[Signature]</i>                                                                                                                                        |              |          |
| DE APPR.                                          |                                                                                                                                                           |              |          |
| DATE                                              | 17.06.09                                                                                                                                                  |              |          |
| DART AEROSPACE LTD<br>HAMKEMURRY, ONTARIO, CANADA |                                                                                                                                                           |              |          |
| DRAWING NO. D2680                                 |                                                                                                                                                           | SHEET 1 OF 9 |          |
| TITLE                                             |                                                                                                                                                           | SCALE        |          |
| 205 SKIDTUBE ASSEMBLY                             |                                                                                                                                                           | NTS          |          |

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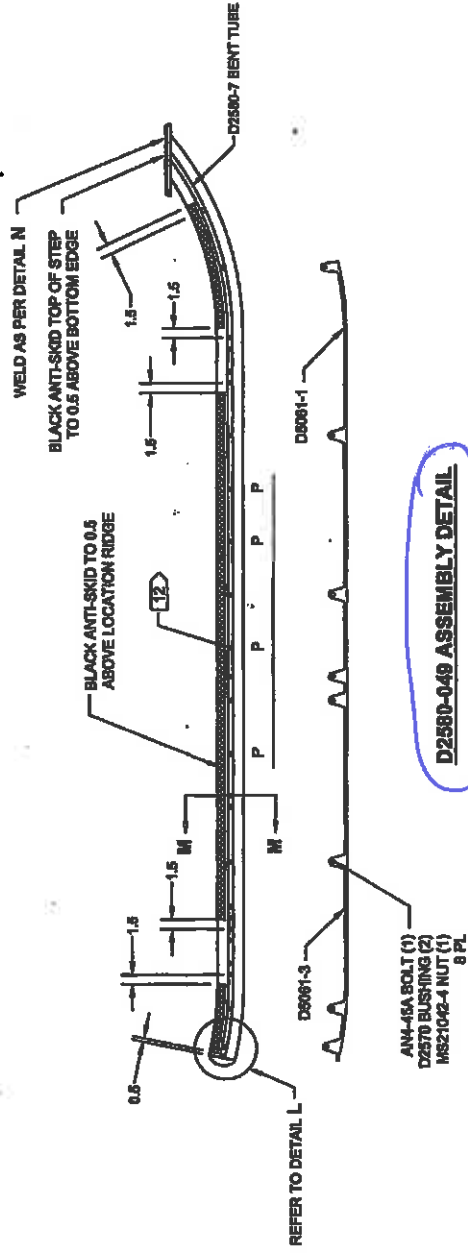


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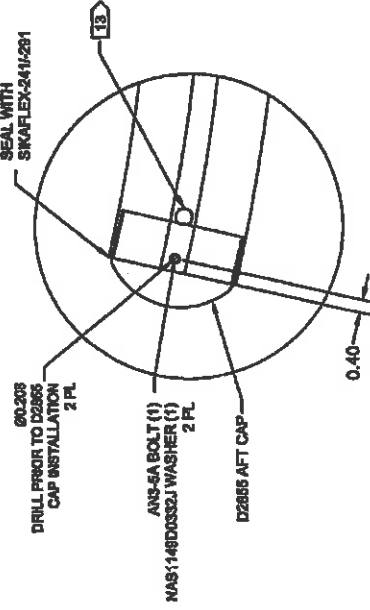
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|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| DESIGN     | DS       | DART AEROSPACE LTD                                                                                                                                                                                                                                                                                   |
| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                          |
| CHECKED    | MS       | DRAWING NO. D2550                                                                                                                                                                                                                                                                                    |
| MPG. APPR. | MS       | REV. H SHEET 8 OF 8                                                                                                                                                                                                                                                                                  |
| APPROVED   | MS       | TITLE 205 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                          |
| DE APPR.   | MS       | SCALE NTS                                                                                                                                                                                                                                                                                            |
| DATE       | 17.08.09 | CONVERTED BY DART AEROSPACE LTD                                                                                                                                                                                                                                                                      |
|            |          | THIS DOCUMENT IS A WORK PRODUCT OF DART AEROSPACE LTD AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. |



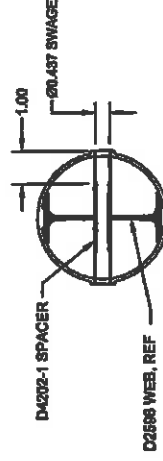


**D2580-049 ASSEMBLY DETAIL**

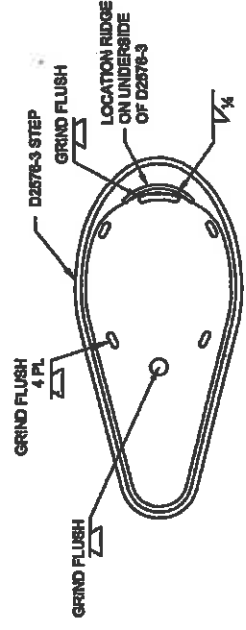
**DETAIL L**  
SCALE 5X



**SECTION M-M**  
SCALE 5X



**DETAIL N**  
SCALE 5X



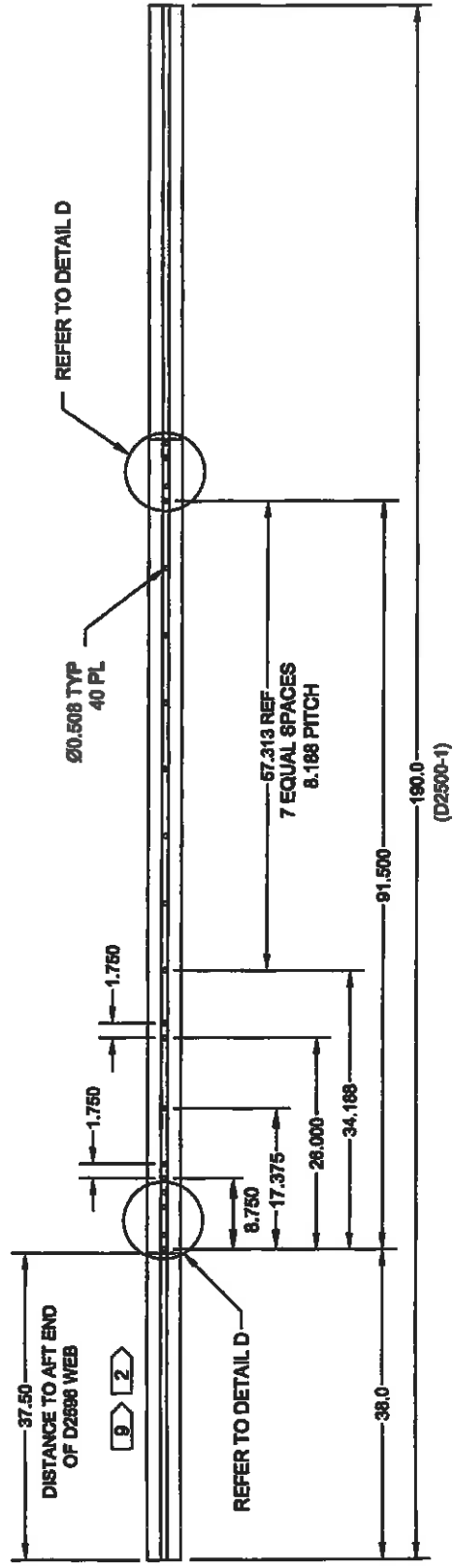
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. INSERT D4025-1 SPACER (24 PLACES)  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER Q81 002  
3. TRIM/GRIND FLUSH PER Q81 002

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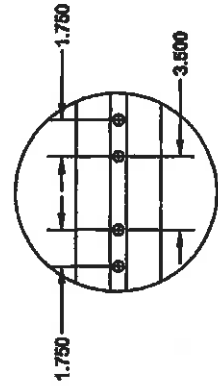
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|------------|----------|-----------------------------|
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| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    |          | DRAWING NO.                 |
| MFG. APPR. |          | D2580                       |
| APPROVED   |          | TITLE                       |
| DE APPR.   |          | 205 SKIDTUBE ASSEMBLY       |
| DATE       | 17.06.09 | SCALE                       |
|            |          | NTB                         |
|            |          | REV. H                      |
|            |          | SHEET 7 OF 8                |

205 SKIDTUBE ASSEMBLY  
DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA



D2590-101 TUBE



DETAIL D  
SCALE 5X

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|            |          |                             |
|------------|----------|-----------------------------|
| DESIGN     | DS       | DART AEROSPACE LTD          |
| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    |          | DRAWING NO. D2590           |
| MFG. APPR. |          | REV. H SHEET 9 OF 9         |
| APPROVED   |          | TITLE                       |
| DIE APPR.  |          | 205 SKIDTUBE ASSEMBLY       |
| DATE       | 17.06.09 | SCALE NTS                   |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                        |             |                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                        |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Job: _____<br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                           |             | DISPOSITION<br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                 |  | DEPARTMENT/PROCESS<br>Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |                                                                                                                                                                                                                                                                                                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #: | QTY Affected :                                                                                                                                                                                                                                                                                                         |  | MRB (QS042)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |                                                                                                                                                                                                                                                                                                        |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                       |             | Disposition                                                                                                                                                                                                                                                                                                            |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                        |  |
| <b>Root Cause</b><br><div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> |             | <b>FAULT CATEGORY</b>                                                                                                                                                                                                                                                                                                  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                        |             | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Other/Details: _____ |  | Contamination <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/><br>Drill Holes <input type="checkbox"/><br>Fit/Function <input type="checkbox"/>                                                                                                                                                                                                                           |  | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain Direction <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set/Set-up <input type="checkbox"/> |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                        |             | Positioned Wrong <input type="checkbox"/><br>Outside Tolerance <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Misread <input type="checkbox"/>                                                                       |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                        |             |                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                        |             | Completed By                                                                                                                                                                                                                                                                                                           |  | Lead hand / Supervisor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                                                                                                                                                                                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                        |             | QC / QA Coordinator                                                                                                                                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                                                                                                                                                                                        |  |